

1/20

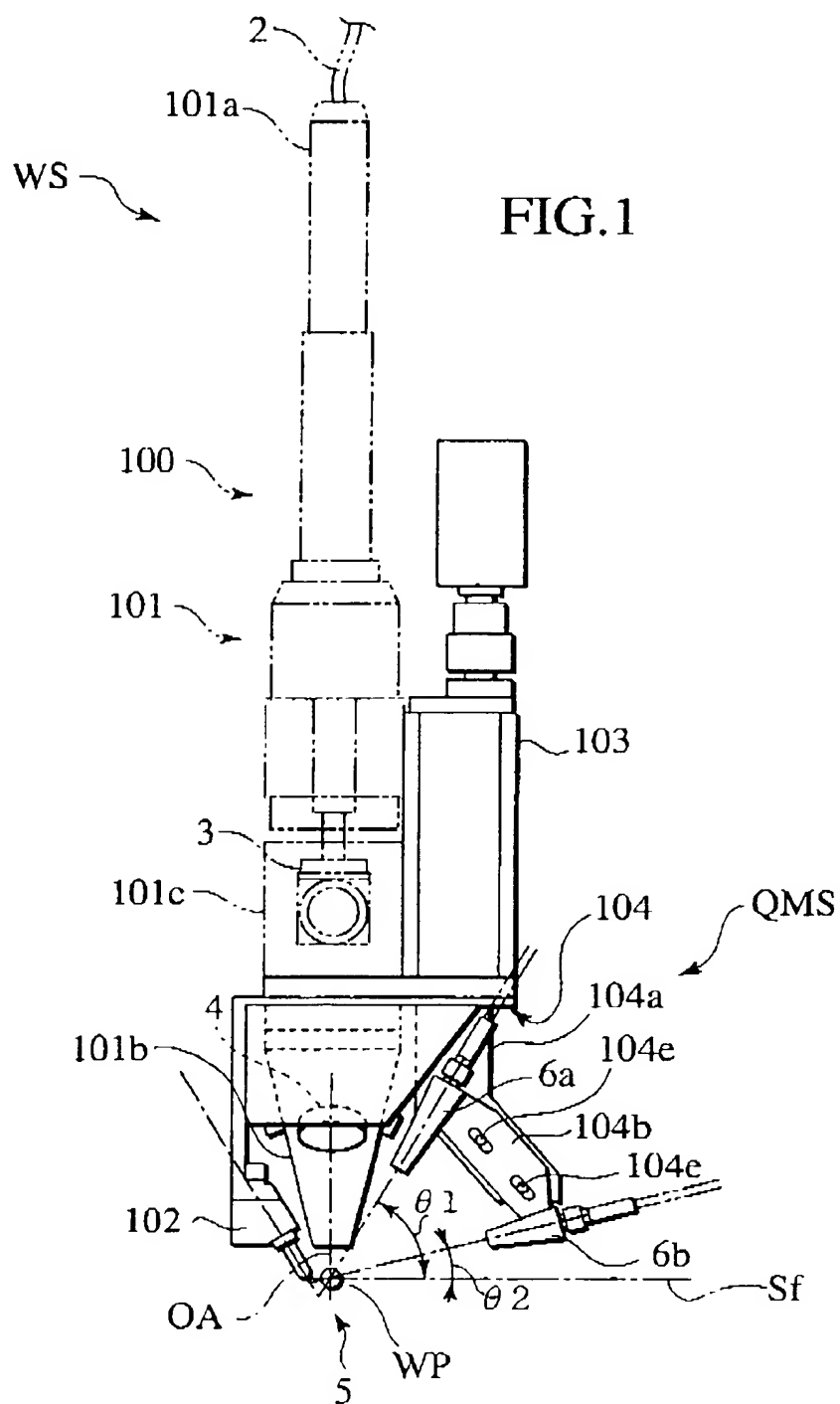
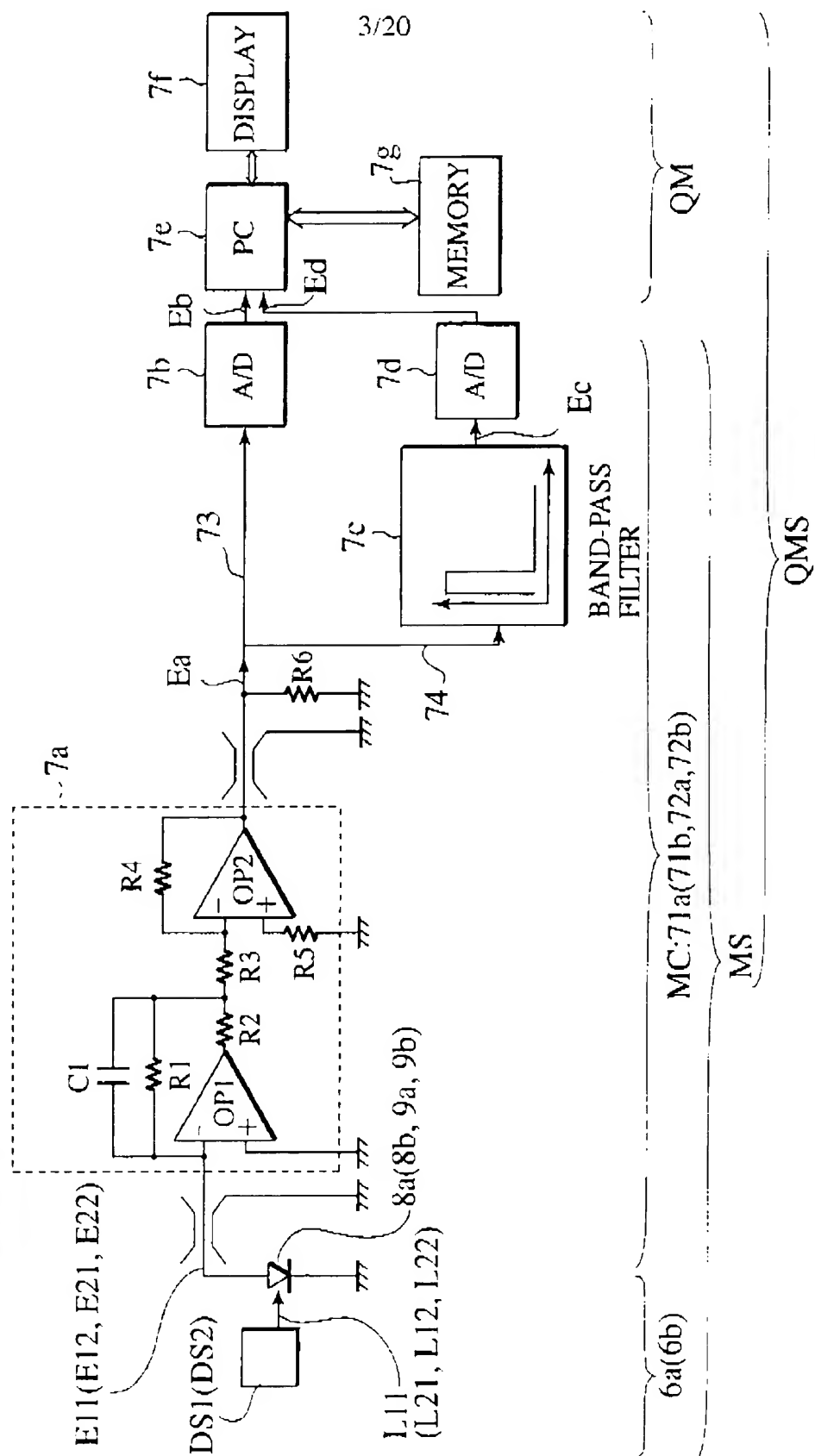


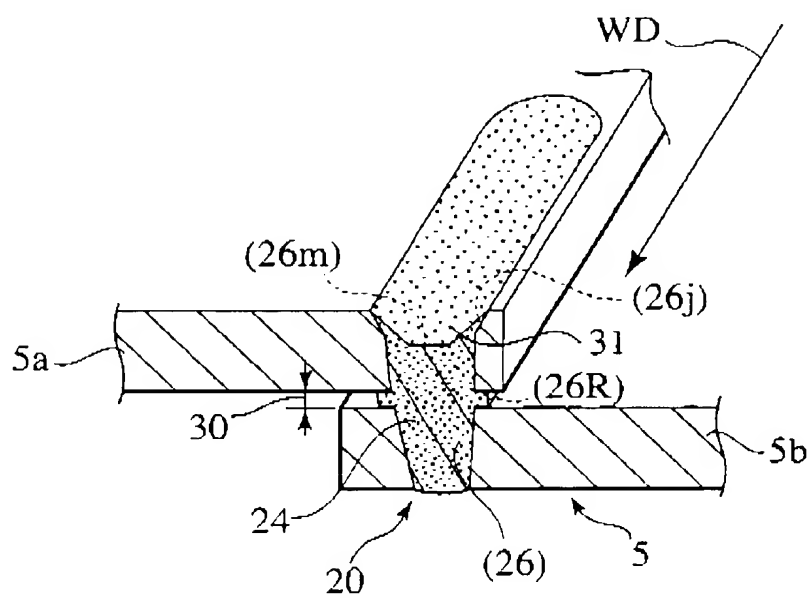
FIG.4

PL:PL1a(PL1b,PL2aPL2b)



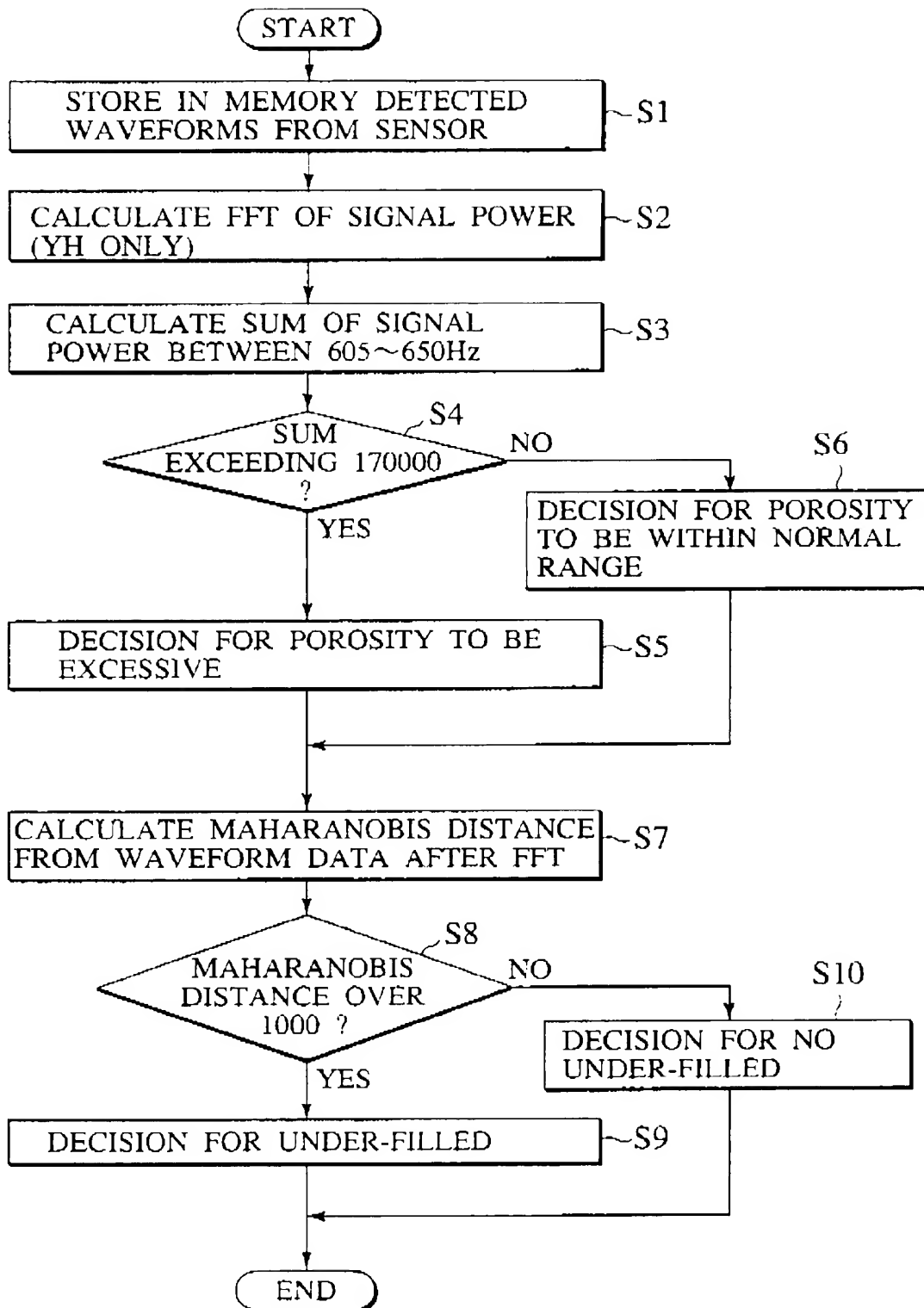
5/20

FIG.7



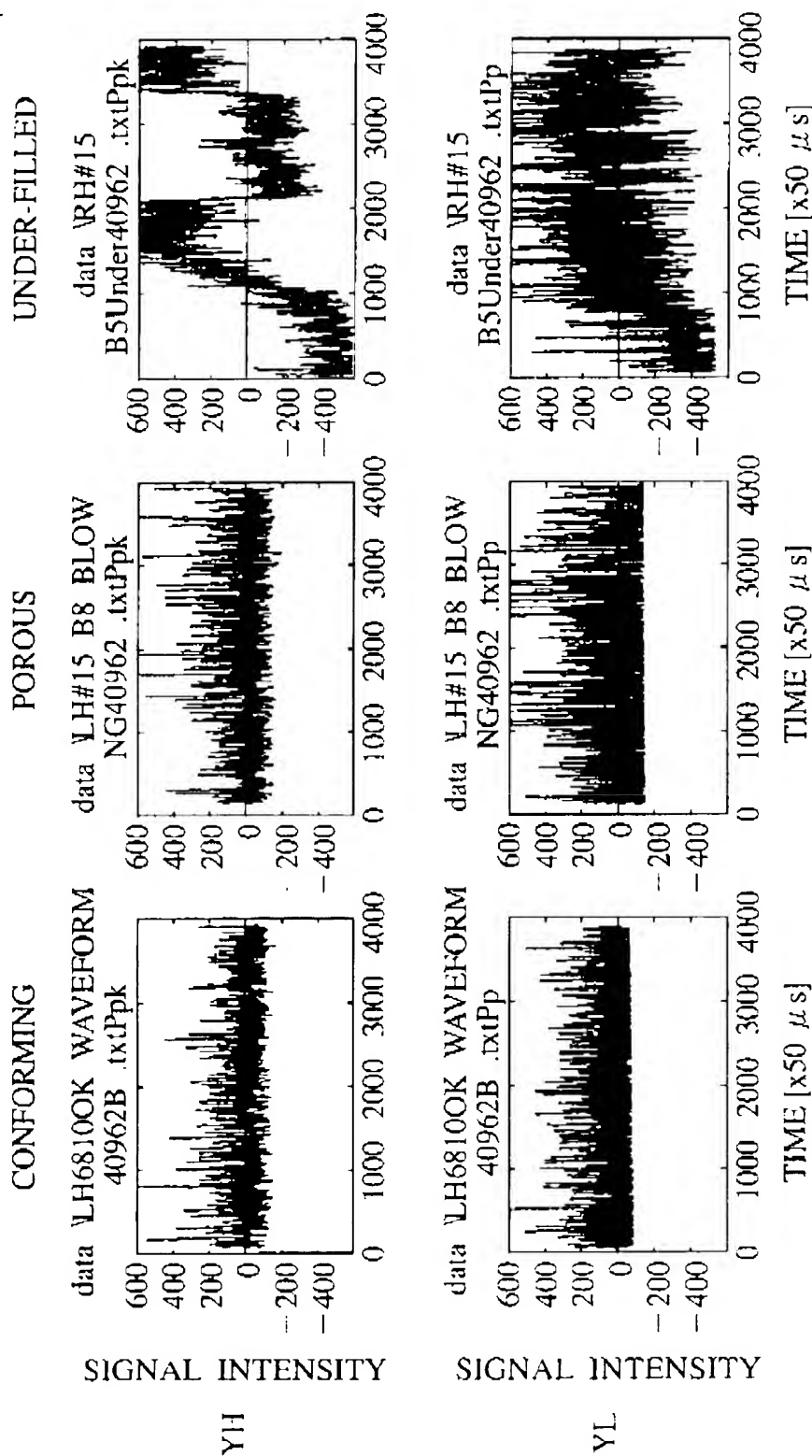
6/20

FIG.8



7/20

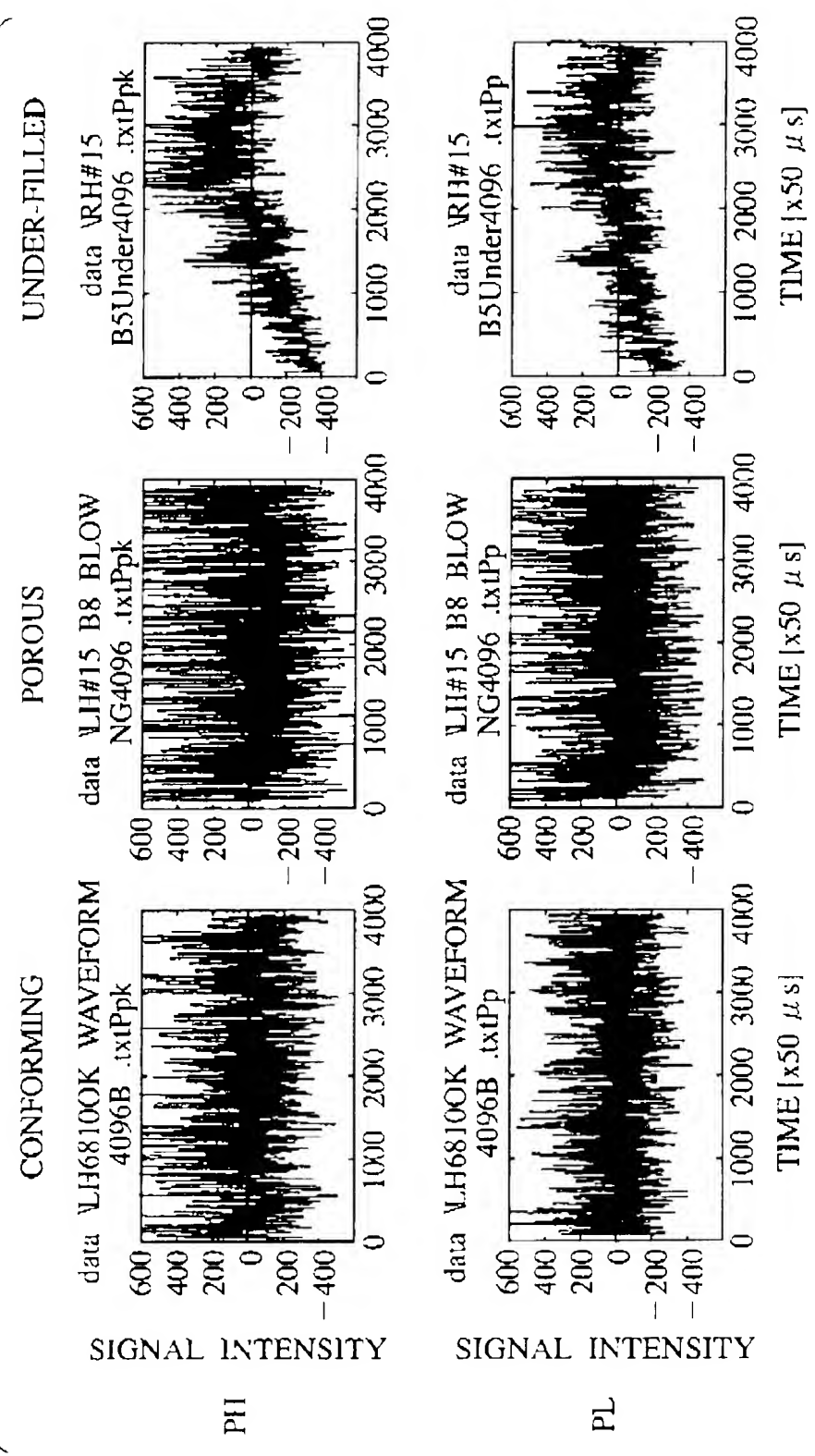
FIG.9



DETECTED WAVEFORMS UNDER BASIC WELDING CONDITIONS

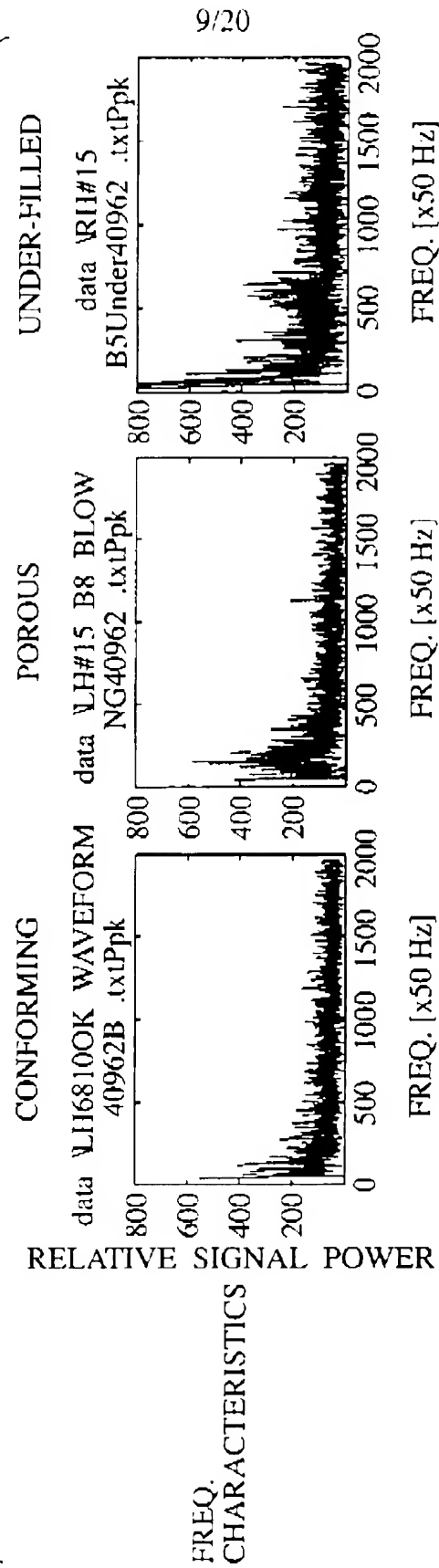
8/20

FIG.10



DETECTED WAVEFORMS UNDER BASIC WELDING CONDITIONS

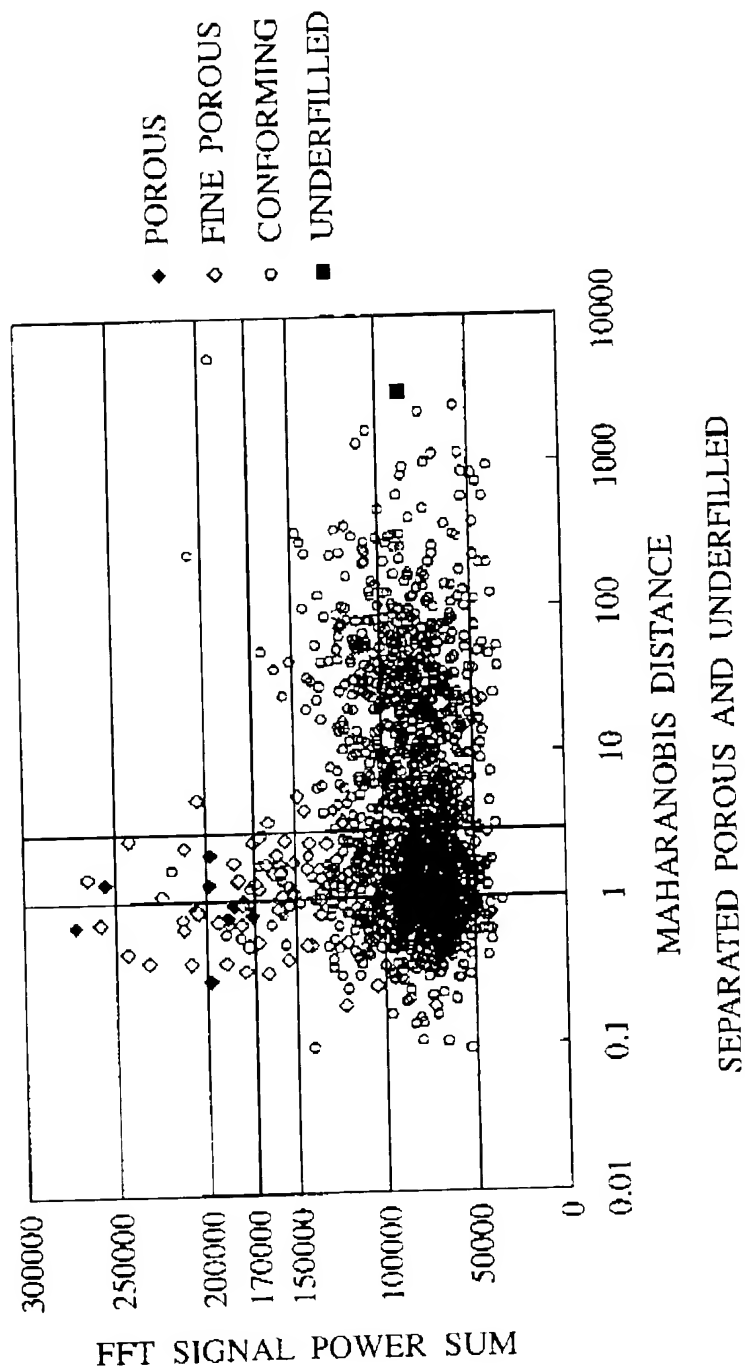
FIG.11



FREQ. CHARACTERISTICS OF YH

10/20

FIG.12



11/20

FIG.13

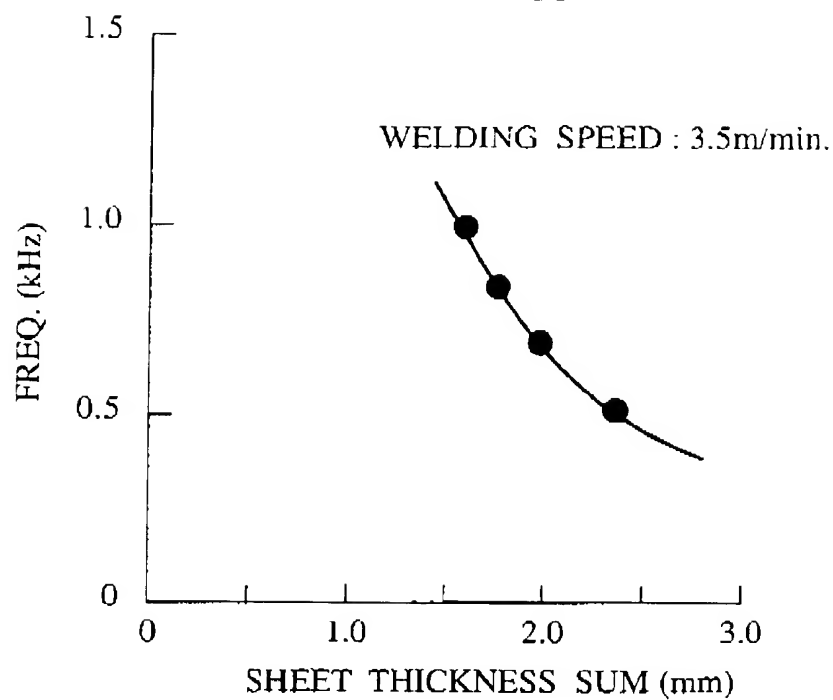
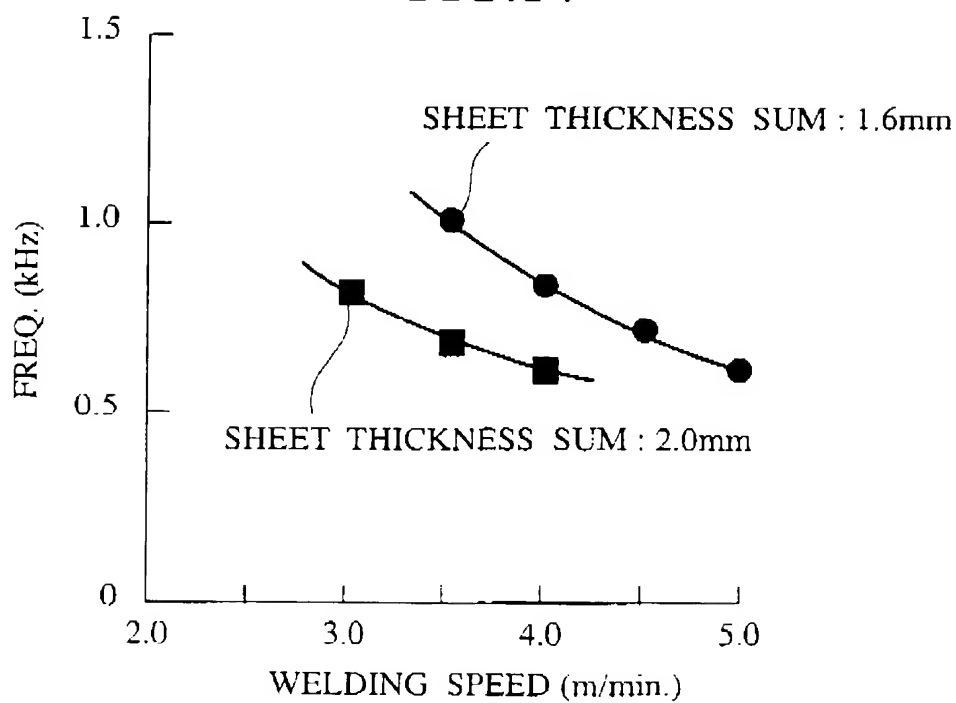


FIG.14



12/20

FIG.15

TABLE-1

		UPPER SHEET t_1			
		LOWER/UPPER	0.8mm	1.0mm	1.2mm
LOWER SHEET t_2	0.8mm	3.5m/min.	3.5m/min.	3.5m/min.	
	"	4.0m/min.			
	"	4.5m/min.			
	"	5.0m/min.			
	1.0mm	3.5m/min.			
	1.2mm	3.0m/min.			
	"	3.5m/min.		3.5m/min.	
	"	4.0m/min.			

13/20

FIG.16

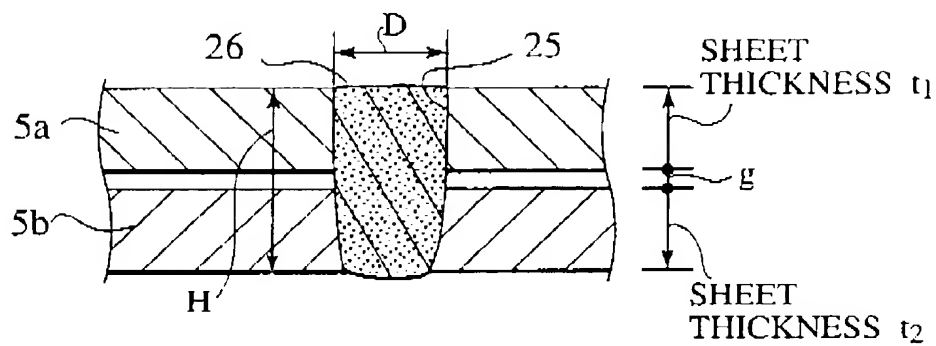


FIG.17

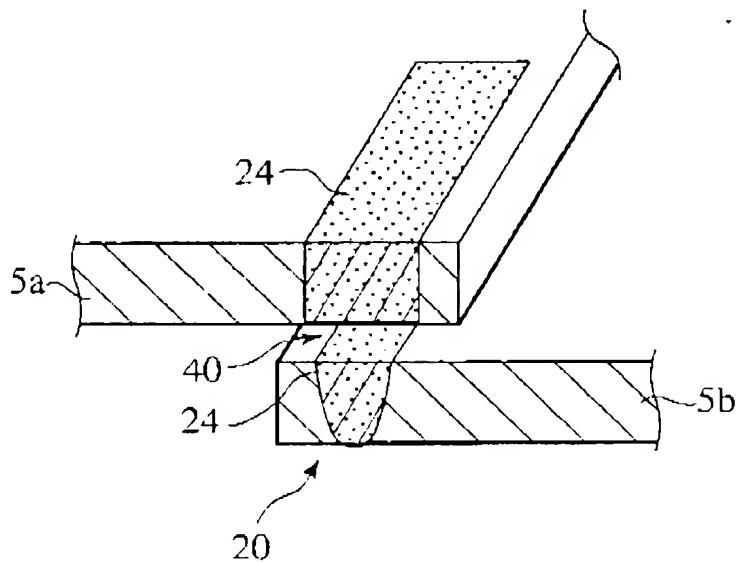
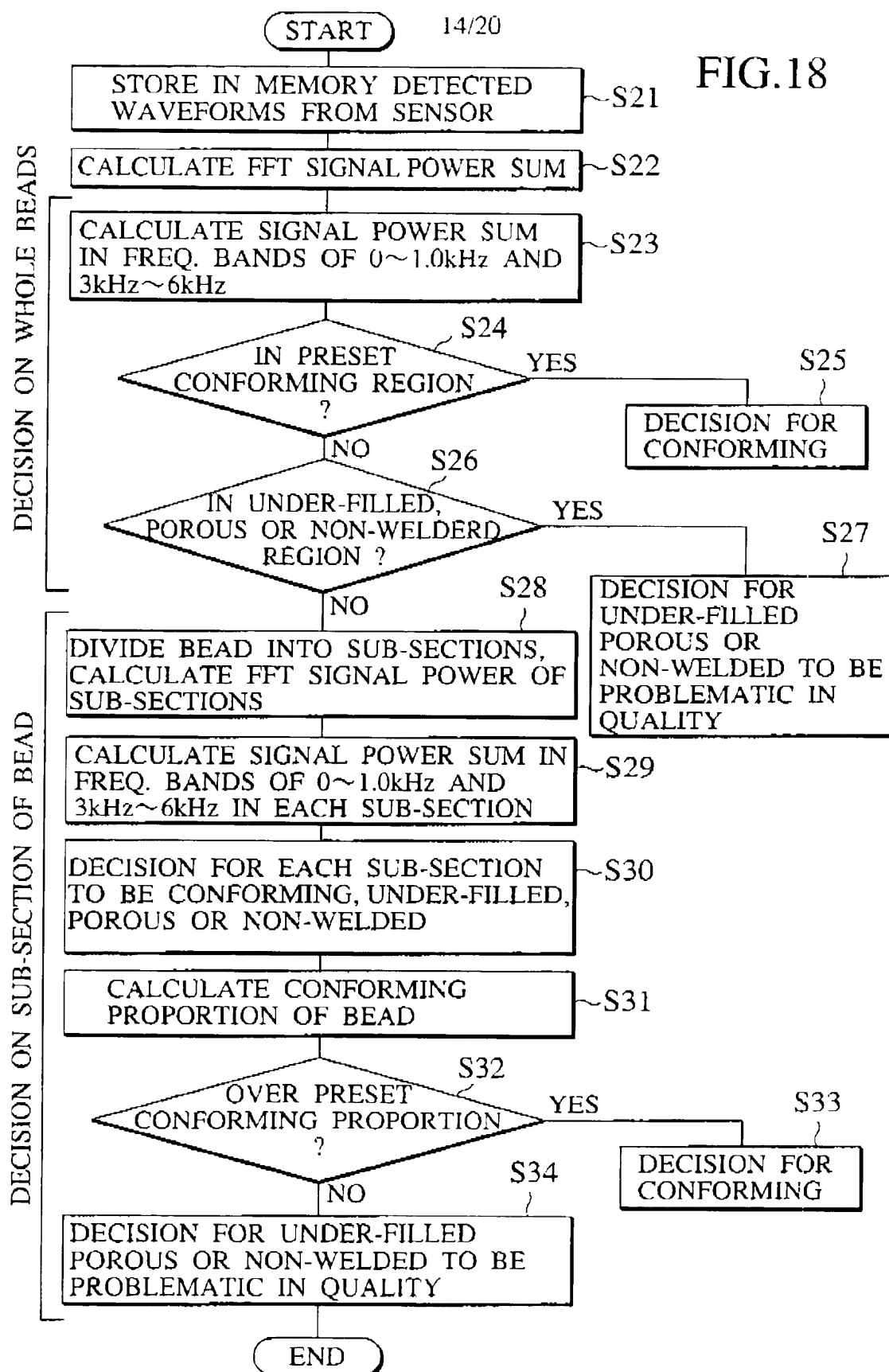
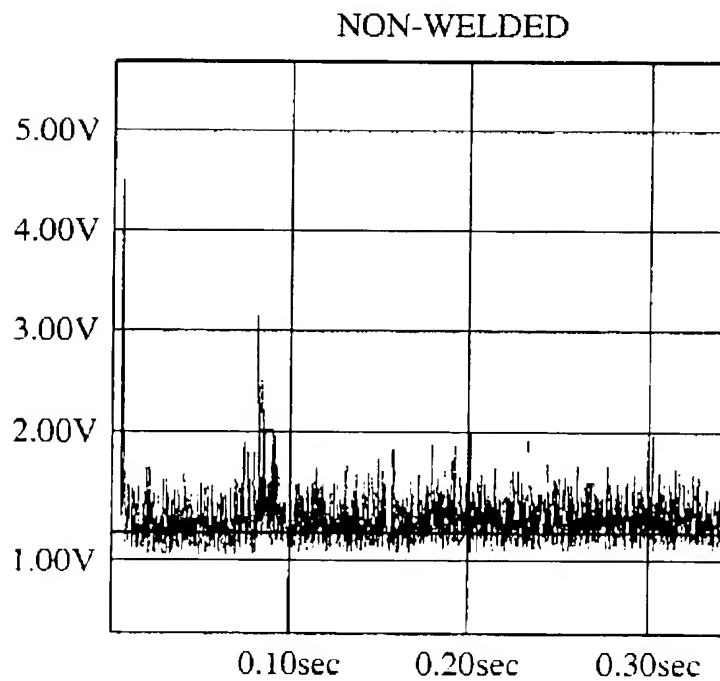
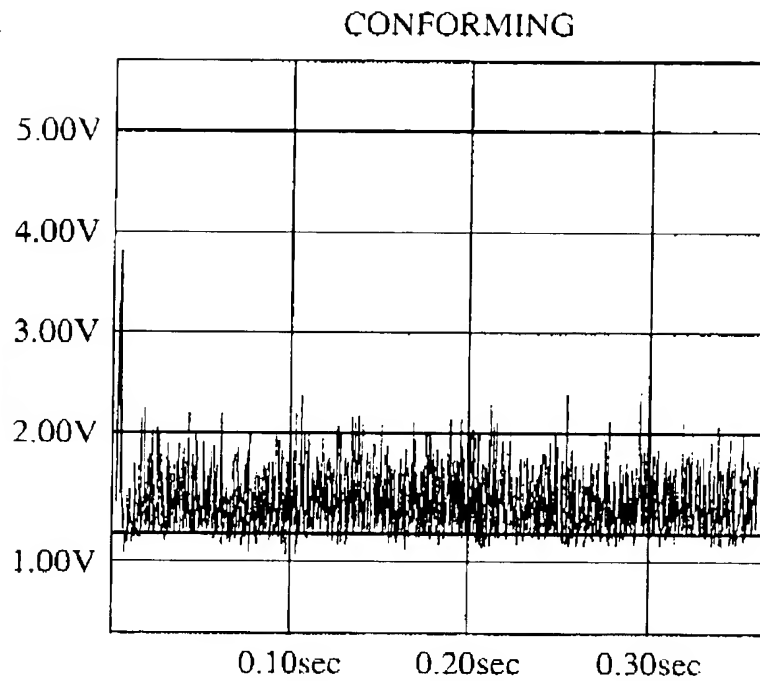


FIG.18



15/20

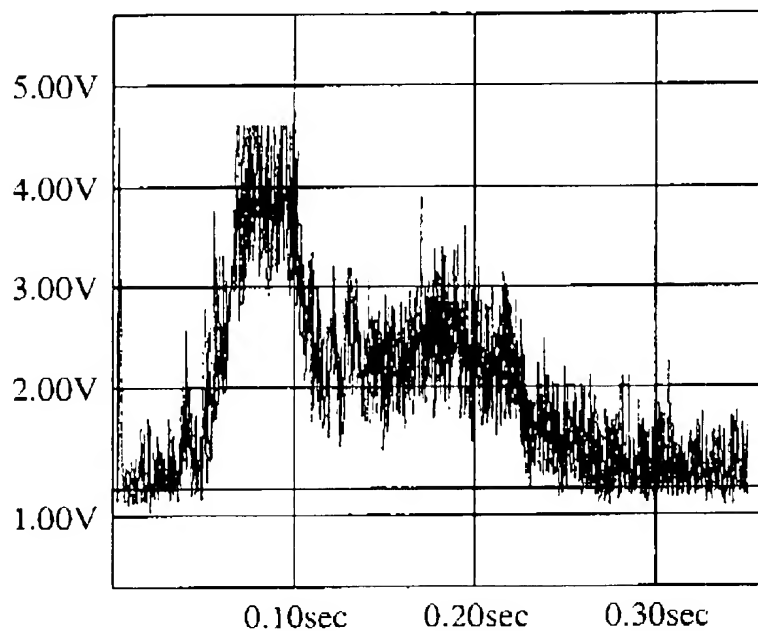
FIG.19



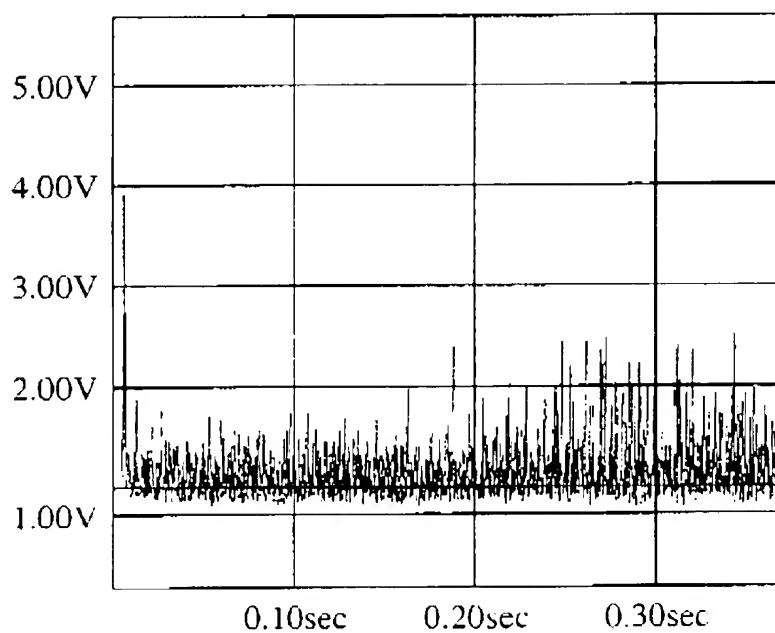
16/20

FIG.20

UNDER-FILLED

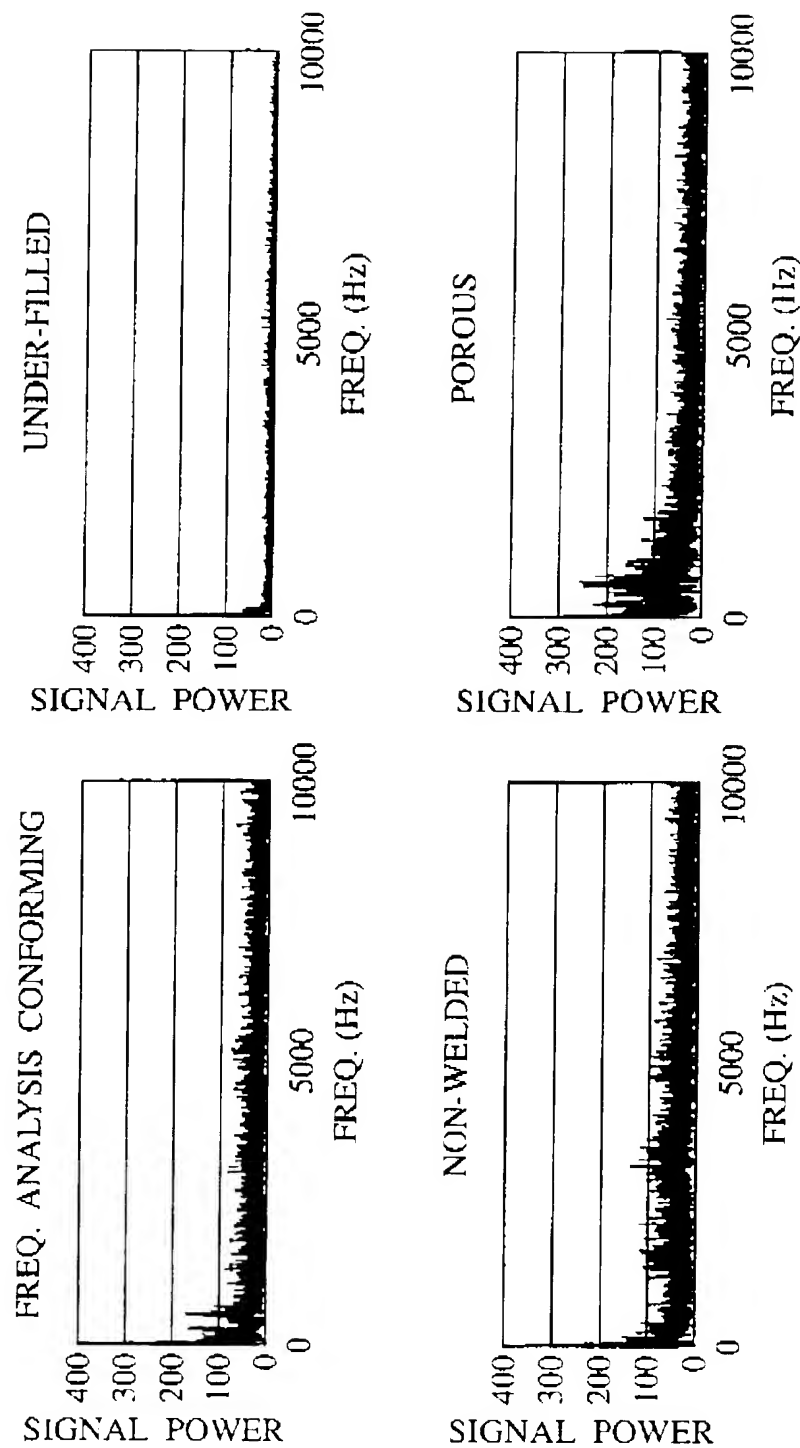


POROUS



17/20

FIG.21



18/20

FIG.22

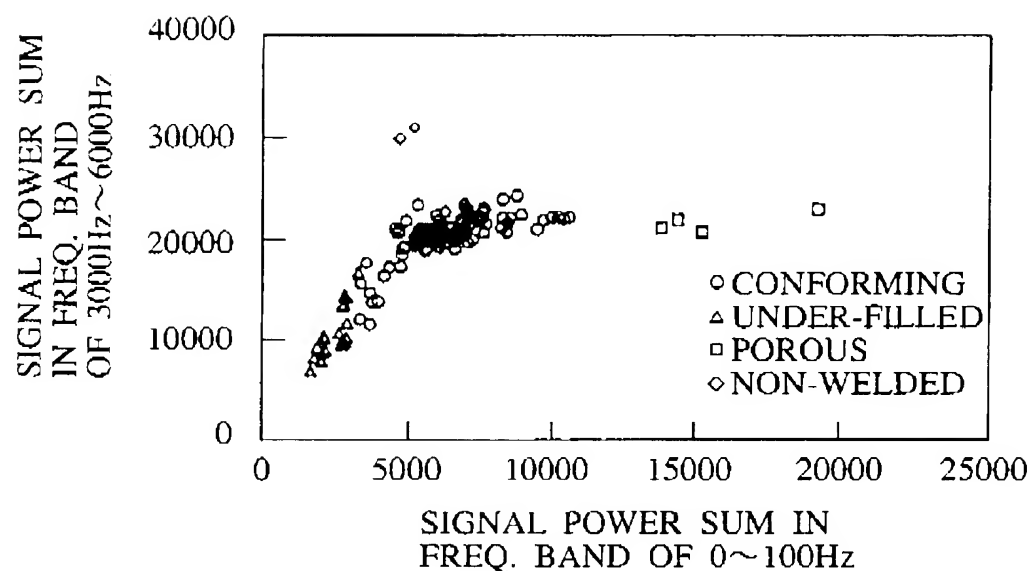
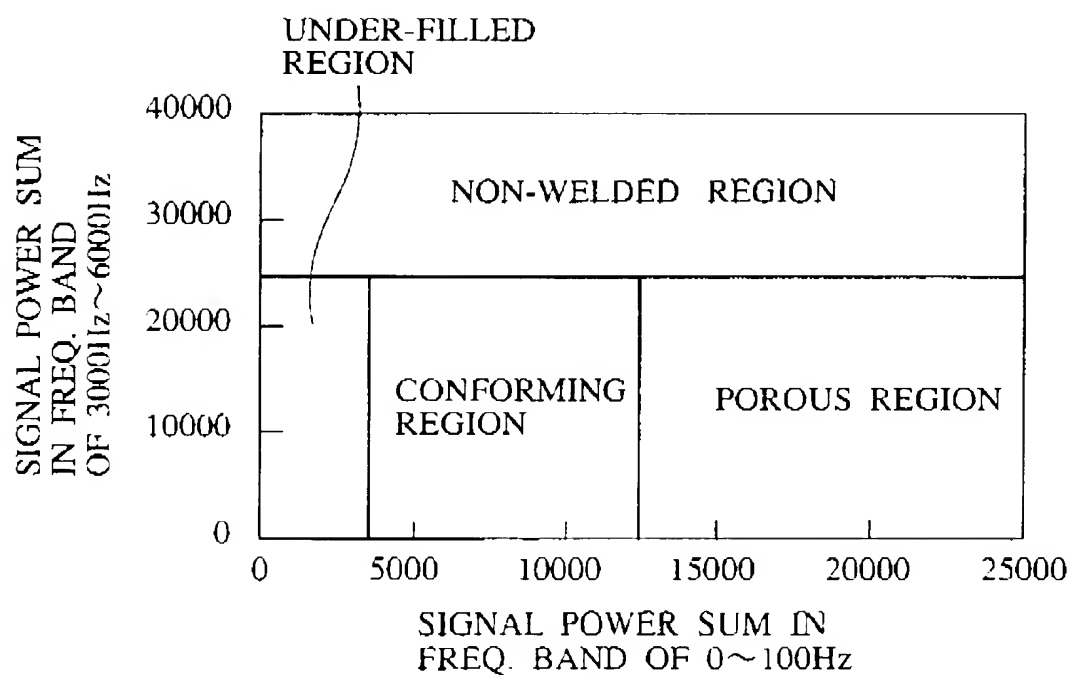


FIG.23



19/20

FIG.24

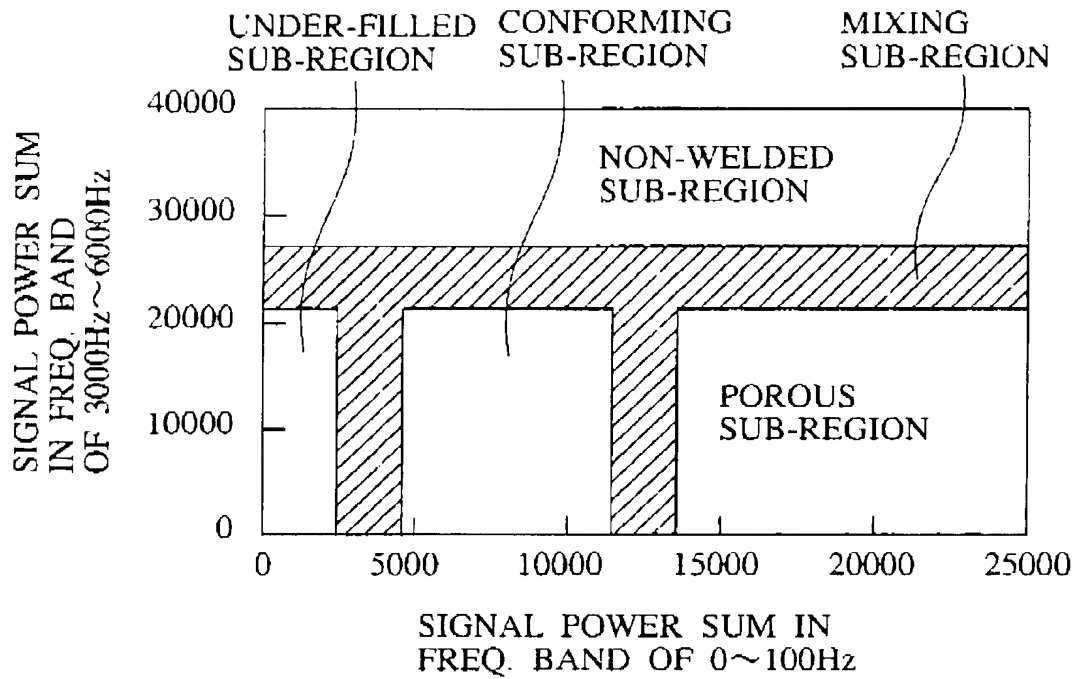
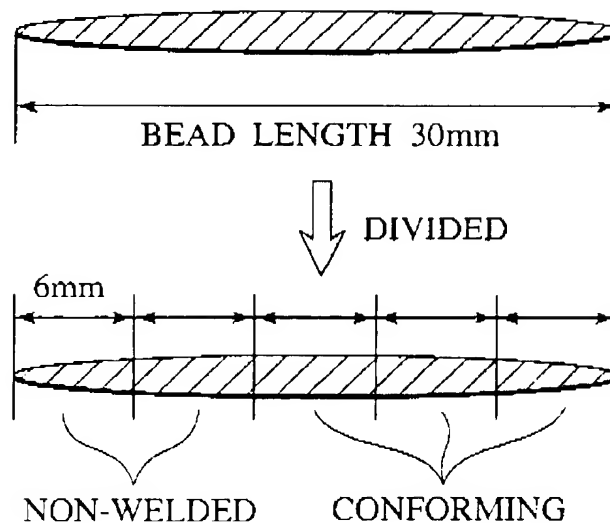


FIG.25



$$\text{CONFORMING PROPORTION} = \frac{\text{CONFORMING LENGTH 6mm} \times 3 \text{ SUB-SECTIONS}}{\text{TOTAL WELD LENGTH 30mm}} = 0.6$$

20/20

FIG.26

